

# Work Order ID 108566

October-21-13 11:10:33 AM

*ASAP - ship 25/10*  
**\*108566\***

Page 1

Item ID: D4519-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Relay Bracket

Start Date: 10/21/13 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 10/23/13 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4519	A								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

*23* 13-10-21

*23* 13-10-21

# Work Order ID 108566

\*108566\*

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Item ID: D4519-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Relay Bracket

Start Date: 10/21/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 10/23/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 13 10 22				23			
140 *140* Brake NC Brake NC	Bend as per dwg NC BRAKE  Memo	0.00 0.00		DAS 30 9-89		23			13/10/22
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 13 10 22				23			

# Work Order ID 108566

\*108566\*

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October-21-13 11:10:33 AM

Item ID: D4519-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Relay Bracket

Start Date: 10/21/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 10/23/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

\*160\*

HandFinish

Memo

0.00

Hand Finishing

23 0 0 Ad  
13-10-22

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

DAS  
27  
9-89

13 10 23

23

180

Identify as per dwg & Stock Location:

0.00

\*180\*

Packaging

Memo

0.00

Packaging

STHTT  
111

13/10/23 23

DAS  
32  
9-89

**Work Order ID 108566****\*108566\***

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October-21-13 11:10:33 AM

Item ID: D4519-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Relay Bracket

Start Date: 10/21/13 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 10/23/13 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

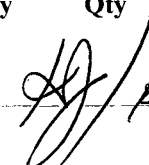
**\*190\***

QC

Memo

0.00

Quality Control

 13-10-23

13-10-23

# Picklist Print

October-21-13 11:10:32 AM

Page 1

Work Order ID: 108566

Parent Item: D4519-1

Parent Item Name: Relay Bracket

Start Date: 10/21/13

Required Date: 10/23/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.01.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	573.7905	0.0378	21		13-10-21	

Location

Loc Qty

Loc Code

MAT021

573.7905

123135

120.2625

124003

72.113

M126075

99.415

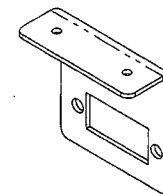
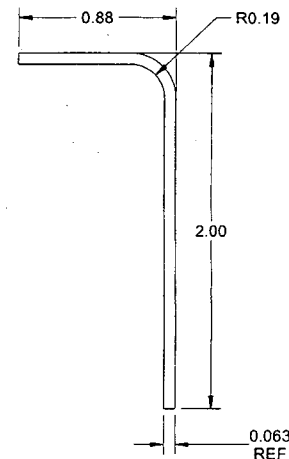
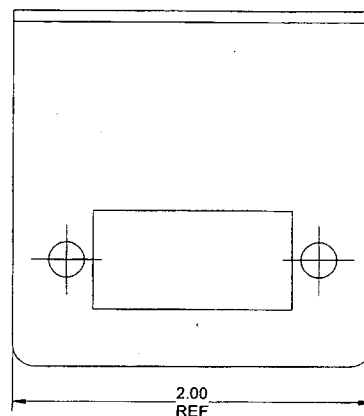
M127006

282

2.31

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	108566
<b>Description:</b> Relay Bracket		<b>Part Number:</b>	D4519-1
<b>Inspection Dwg:</b> D4519	<b>Rev:</b> A	<b>Page 1 of 1</b>	

[illegible]



# **D4519-1 RELAY BRACKET**

RELEASED  
2012-01-17  
ND

## **NOTES:**

- 1) MATERIAL: MAKE FROM D4519-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

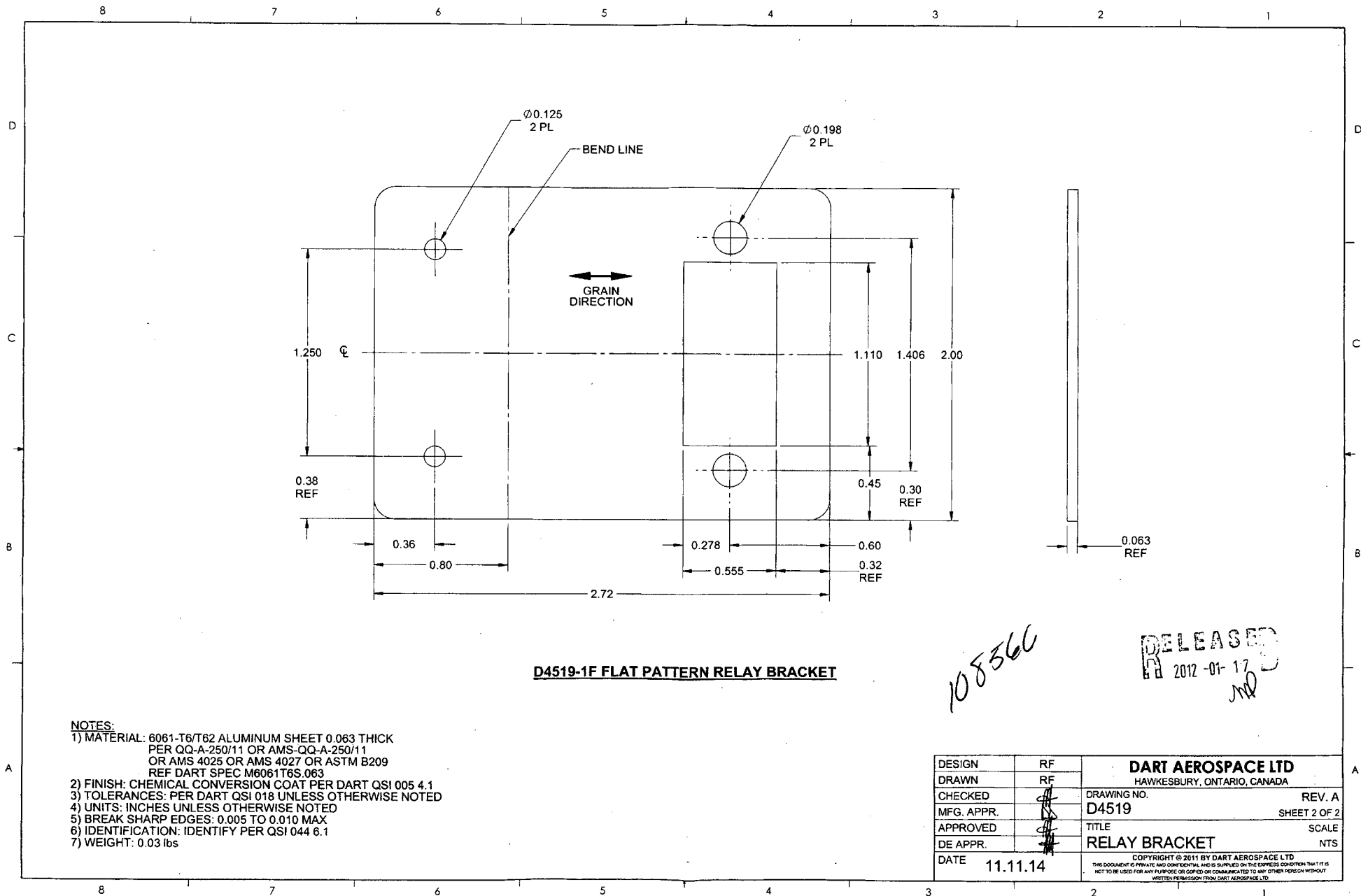
*a/o 108566*

A NEW ISSUE		RF	11.11.14
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.11.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4519** REV. A  
SHEET 1 OF 2  
TITLE **RELAY BRACKET** SCALE NTS

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108366

RELEASED  
2012-01-17  
MD